

Date: Tuesday, 7/17/2007 1:59:53 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 412 GROSS WEIGHT TOWING KIT
 Job Number : 33583
 Estimate Number : 12592
 P.O. Number : *N/A* Part Number : D412666011
 This Issue : 7/17/2007 S.O. No. : *N/A* Drawing Number : D412-666 REV B
 Prsht Rev. : NC Project Number : N/A
 First Issue : *N/A* Type : SMALL / MED FAB Drawing Revision : B
 Previous Run : 29605 Material : *N/A*
 Due Date : 8/10/2007 Qty: 4 Um: Each
 Written By : *[Signature]*
 Checked & Approved By : *[Signature]* 07.07.17
 Comment : Est Rev:B Added GHG 002 NG 02-03-06

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: Photocopy bluefile & type labels per PPP412-666-011

CHG 002
En 07/09/14

2.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
 Pick Packing Kit

3.0 D2888 Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Lug

Batch: *B333595, 50*

4.0 AN615A Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Bolt

Batch: *M102832, 50*

5.0 AN643A Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Bolt

Batch: *M102832, 7/9/14 50*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: 12 Date: 21/09/14
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 7/17/2007 1:59:53 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 412 GROSS WEIGHT TOWING KIT

Job Number: 33583

Part Number: D412666011

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

AN960JD616

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total: 32.0000 Each(s)

Washer

Batch: M104537

59

7.0

MS21042L6

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)

Nut

Batch: M104021

7/9/14

50

8.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

En

07/02/14

24/4/14

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-666-011

Location:

PPP Rev: 0

2/7/9/14

(4)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/02/14

(4)

Job Completion



11 07-09-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN #	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D412-666	REV. B SHEET 1 OF 1
DATE 02.03.04		TITLE 412 GROSS WEIGHT TOWING KIT	SCALE 1:3
A	99.05.03	NEW ISSUE	
B	02.03.04	UPDATE KIT FOR BOTH SKIDTUBES AND COMPATIBILITY WITH DART CROSSTUBES	

APPLICABILITY:

GROSS WEIGHT TOWING KIT D412-666-011 MAY BE INSTALLED ON DART D205-634-011 SKIDTUBES INSTALLED ON 412 AIRCRAFT TO ALLOW GROUND HANDLING AT GROSS WEIGHT IN ACCORDANCE WITH BELL SERVICE INSTRUCTION BHT-412-SI-58. IT IS ALSO ACCEPTABLE TO INSTALL THIS KIT ON 204/205/212 AIRCRAFT EQUIPPED WITH DART SKIDTUBES IN ORDER TO PRESERVE THE LIFE OF THE AFT CROSSTUBES. THIS KIT CONTAINS ENOUGH PARTS TO INSTALL D2888 LUGS ON BOTH SKIDTUBES.

PARTS LIST:

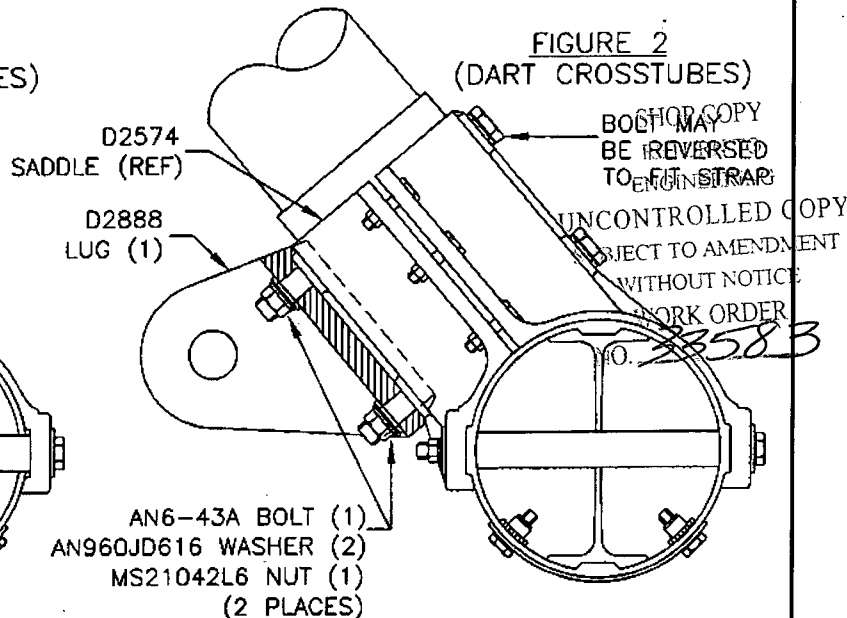
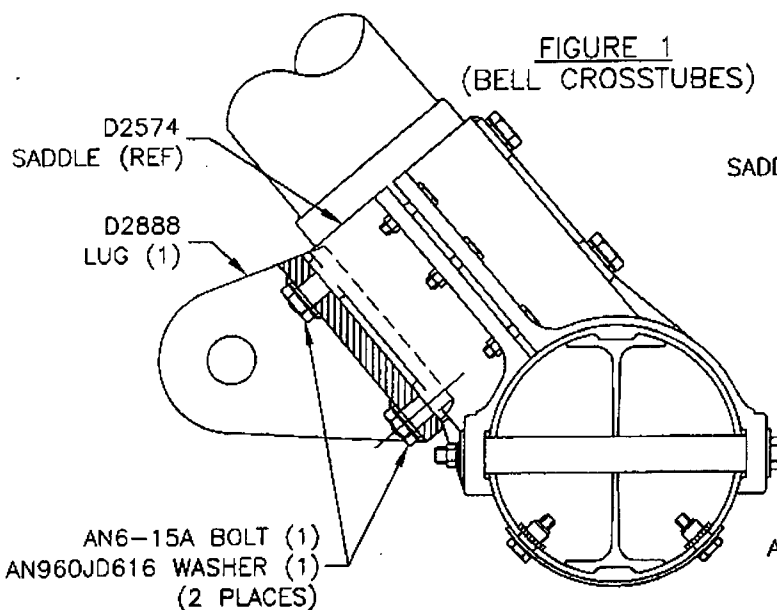
-011	PART	DESCRIPTION
X	D412-666-011	GROSS WEIGHT TOWING KIT
2	D2888	LUG
4	AN6-15A	BOLT
4	AN6-43A	BOLT
8	AN960JD616	WASHER
4	MS21042L6	NUT (or MS21042-6)

WEIGHT AND BALANCE:

INSTALLATION	WEIGHT	LONGITUDINAL	
		ARM	MOMENT
D412-666-011	1.90 lb 0.86 kg	163.0 in 4.14 m	310 in lb 3.56 m kg

PROCEDURE:

- 1) REMOVE AN6-12A BOLTS (4) ON INBOARD SIDE OF AFT SADDLE AND DISCARD. ON LANDING GEAR WITH DART AFT CROSSTUBES, REMOVE (4) AN6-40A BOLTS.
- 2) INSTALL D2888 LUGS WITH AN6-15A BOLTS (2) AS SHOWN IN FIGURE 1. USE AN6-43A (2) BOLTS ON DART CROSSTUBES, AS SHOWN IN FIGURE 2.
- 3) TORQUE BOLTS PER INSTALLATION INSTRUCTIONS D205-634.



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 Estimate Number : 12592
 P.O. Number :
 This Issue : 7/17/2007 S.O. No. :
 Prsht Rev. : NC Part Number : D412666011
 First Issue : 11 Type : SMALL /MED FAB Drawing Number : D412-666 REV B
 Previous Run : 29605 Project Number : N/A
 Material :
 Due Date : 8/10/2007 Qty: 4 Um: Each
 Written By :
 Checked & Approved By : *07.07.17*
 Comment : Est Rev:B Added GHG 002 NG 02-03-06

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: Photocopy bluefile & type labels per PPP412-666-011 CHG 002/003

2.0 PACKAGING 1 PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Pick Packing Kit*07.07.30*

3.0 D2888 Lug

Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)
Lug
Batch: _____

4.0 AN615A Bolt

Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)
Bolt
Batch: _____

REFERENCE ONLY

5.0 AN643A Bolt

Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)
Bolt
Batch: _____

Date: Friday, 07/09/2007 9:10:41 AM
 User: Linda Lacelle

Process Sheet

-011

Customer : CC-DAR01 Dart Aerospace Ltd.	Drawing Name : D412-666
Job Number : 34452	
Estimate Number : 10804	
P.O. Number : <i>N/A</i>	Part Number : Z_CUSTOM
This Issue : 07/09/2007 S.O. No. : <i>N/A</i>	Drawing Number : ECN1025
Prsht Rev. : NC	Project Number : <i>N/A</i>
First Issue : 07/09/2007 Type : MACHINED PARTS	Drawing Revision : <i>N/A</i>
Previous Run : 00015	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 14/09/2007 Qty: 1 Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment :	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

PULL FROM STK:

20676 2X
 3 X D412-666 B *33583 4X 8X*
 REPLACE AN6-43A BOLTS B *11328* - RESTOCK

WITH AN6-45A BOLTS B *105053 24X*
 + NEW PAPERWORK

*4102832 16x**7/9/26 6x*

2.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
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Comment: INSPECT 100% KITS FOR COMPLETENESS

on 07/09/26 (46)

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

REPACKAGE PER PPP
 USING SAME B/N

*34709**SP*

4.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

ADD A COPY OF THIS W/O WITH THE ABOVE W/O

D 07/09/28 (1)

Job Completion

*U 07/09/28*